

D 205.63304

Work Order ID 58285

May 3, 2010 10:23:21 AM



Item ID: D2563

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 5/03/10 Start Qty: 6.00



Cust Item ID:

Required Date: 5/07/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2563

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Debur ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10.06.02

6

10.06.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Sequence ID/
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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control



Cust Item ID:

Customer:



8/10/06/02

10.06.02

SAD 10-06-02

46

6

6

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 5/07/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Weld per dwg A/R Aluminum rod Batch: m112860
Large Fab

0.00

10.06.03

6

Large Fab

Memo

Large Fab

1-Inspect for foreign object per QSI 024

2-Weld Remaining End cap as per Dwg D2563 using DT 8343

3-Grind

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

Quality Control

0.00

(6) 10.06.04

170

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

0.00

10.06.04

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 58285

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6

Page 4

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Cust Item ID:

Required Date: 5/07/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

→ Touch up Alodine then
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1114207

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:15am
460°F
10:45am

6 BK 10-6-7.

11 10/04/07

6

190

Wing Walk as per dwg QSI005 4.4 Batch 114432 0.00



HandFinish

Memo

0.00

Hand Finishing

6 BK 10-6-7

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7m-h 10/06/07 6X

W/O:		WORK ORDER CHANGES					
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Work Order ID 58285

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Item Name: Step Weldment Assembly

Start Date: 5/03/10

Start Qty: 6.00



Cust Item ID:

Required Date: 5/07/10

Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPD 58285

0.00

44/8 (e)

Packaging

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/09
R10-6-08
(e)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 3, 2010 10:23:19 AM

Page 1

Work Order ID: 58285

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 5/03/10

Required Date: 5/07/10

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
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D2244-116		Manufactured	No			100	Each	0.0421	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	--	--	--



Step Extrusion

Location	Loc Qty	Loc Code
----------	---------	----------

WA 357850	0.0421	
38023	0.0421	

D2561		Manufactured	No			100	Each	5.0000	2			
-------	--	--------------	----	--	--	-----	------	--------	---	--	--	--



Lug

Location	Loc Qty	Loc Code
----------	---------	----------

MEZZ 358430	5	
53616	5	

D2564		Manufactured	No			100	Each	15.0000	2			
-------	--	--------------	----	--	--	-----	------	---------	---	--	--	--



Mounting Angle

Location	Loc Qty	Loc Code
----------	---------	----------

MEZZ 358431	15	
56292	15	

D2673-34		Manufactured	No			100	Each	35.0000	1			
----------	--	--------------	----	--	--	-----	------	---------	---	--	--	--



End Plate

Location	Loc Qty	Loc Code
----------	---------	----------

WA	35	
57527	35	



10.06.01



10.06.01



10.06.01



10.06.02

6

12

7
5

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

May 3, 2010 10:23:20 AM

Page 2

Work Order ID: 58285



Parent Item: D2563



Parent Item Name: Step Weldment Assembly

Start Date: 5/03/10

Required Date: 5/07/10

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2673-34		Manufactured	No			150	Each	35.0000	1			



End Plate



R 10-06-03

Location

Loc Qty

Loc Code

WA

35

57527

35

6

May 3, 2010 10:23:20 AM

Shop Packet Print

Page 2

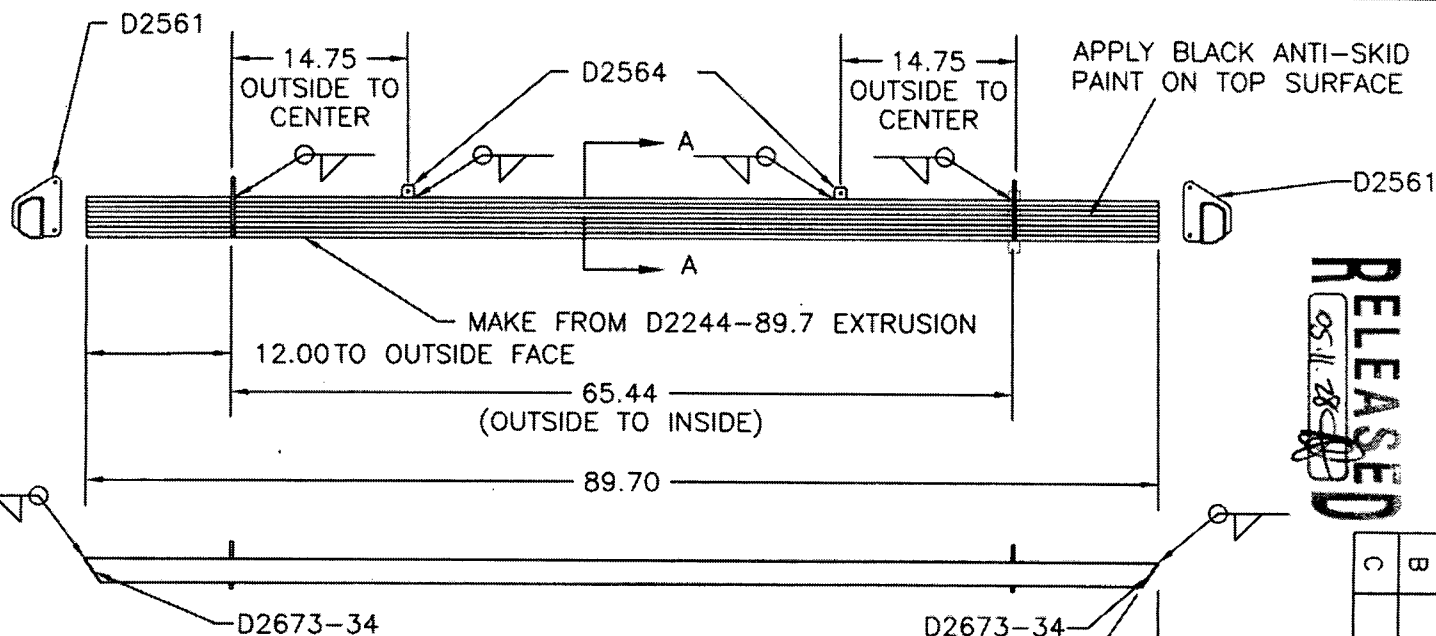
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

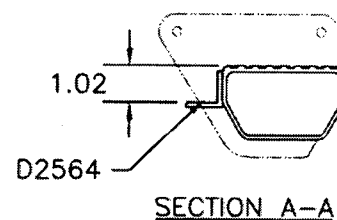
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DART**RELEASED**
05.11.28**D2563 STEP WELDMENT ASSEMBLY PARTS LIST**

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

**SECTION A-A****D2563 STEP WELDMENT ASSEMBLY NOTES**

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 052283
0510-509

DESIGN	BW	DRAWN BY	Ht	DART AEROSPACE LTD	REV. C
CHECKED		APPROVED		DRAWING NO. D2563	SHEET 1 OF 1
DATE	05.11.14	TITLE	STEP WELDMENT ASSEMBLY	SCALE	1:15
A	96.04.26	NEW ISSUE			
B	97.05.14	END CAPS CHANGED (WAS D2248)			
C	05.11.14	UPDATE NOTES			

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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